

# Work Order ID 52952

October 19, 2009 11:50:42 AM

Page 1

Item ID: D3983-9

Revision ID: A

Item Name: Spacer

Start Date: 10/19/09 Start Qty: 1.00

Required Date: 10/23/09 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date: 09/10/09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3983	A
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100



Hardinge

Hardinge CNC Lathe Small

Memo

1- Turn as per folio FA859 dwg D3983

2- Deburr

0.00

0.00

SA 09/10/20

22 0

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

SA 09/10/20

22 0

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

anf 09/10/20

22 0

# Work Order ID 52952

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Page 2

Item ID: D3983-9

Accept

Setup Start

Revision ID: A

Stop

Item Name: Spacer

Start Date: 10/19/09 Start Qty: 1.00

Cust Item ID:

Required Date: 10/23/09 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 Chemical Conversion Coat per QSI005 4.1

0.00  
PR 09-10-20

(22)



HandFinish

Memo

0.00

Hand Finishing

140 QC3- Inspect Part Finish

0.00  
JH 09/10/20

(22)

(XO)



QC

Memo

0.00

Quality Control

150 Identify as per dwg & Stock Location: 135

0.00

(09/10/21) (22)



Packaging

Memo

0.00

Packaging

# Work Order ID 52952

October 19, 2009 11:50:42 AM

Page 3

Item ID: D3983-9

Accept

Revision ID: A

Item Name: Spacer

Start Date: 10/19/09 Start Qty: 1.00

Required Date: 10/23/09 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/10/21  
MF  
09-10-21

# Picklist Print

October 19, 2009 11:50:47 AM

Page 1

Work Order ID: 52952

Parent Item: D3983-9

Parent Item Name: Spacer

Start Date: 10/19/09

Required Date: 10/23/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6R0.625		Purchased	No			100	f	108.3857	0.0465			
6061-T6 Round Bar .625"												

M6061-T6 R 8 -500"

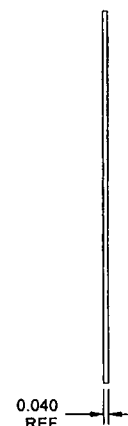
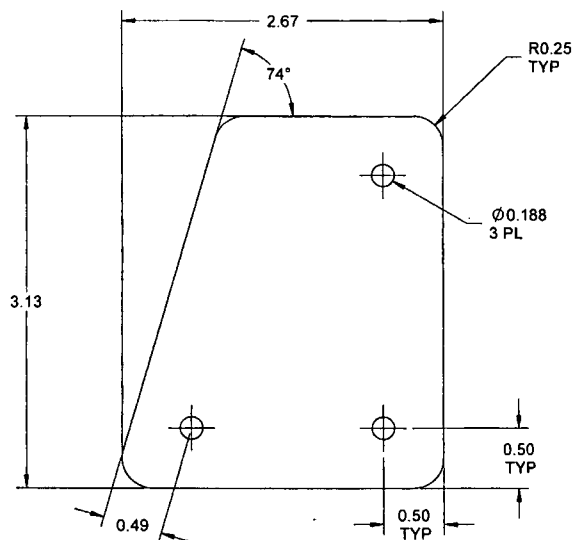
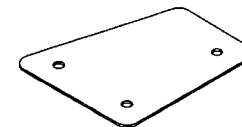
<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	108.3857	
109733	5.72	
110250	11.79	
111650	14.6157	
112611	16.26	
112697	60	

111448

1.0824 SA 09/10/20







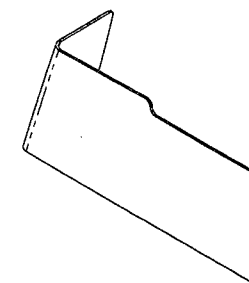
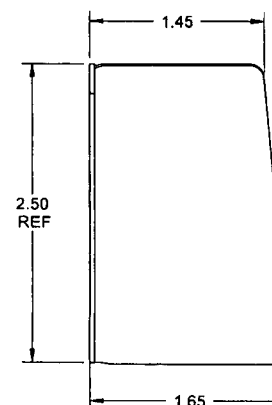
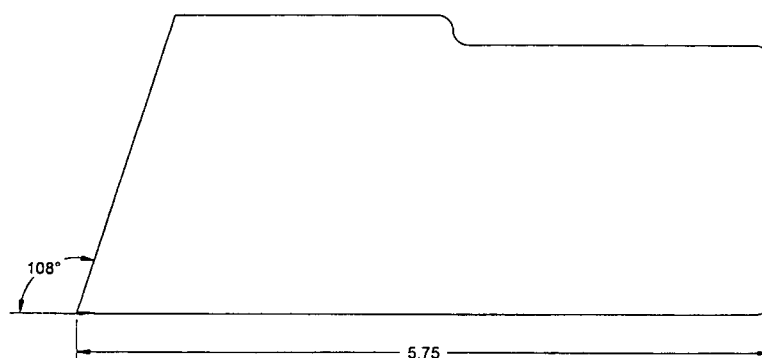
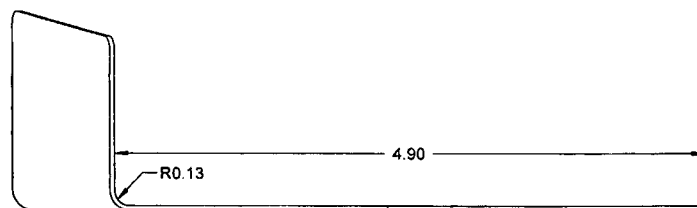
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# **D3983-3 INNER CLOSEOUT**

**RELEASED**  
2009-10-13  
*MP*

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.040
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-3" AND B/N USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.03 lbs

DESIGN	<i>JS</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	<b>D3983</b>	SHEET 2 OF 7
APPROVED	<i>JS</i>	TITLE	SCALE
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DATE	09.09.09	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



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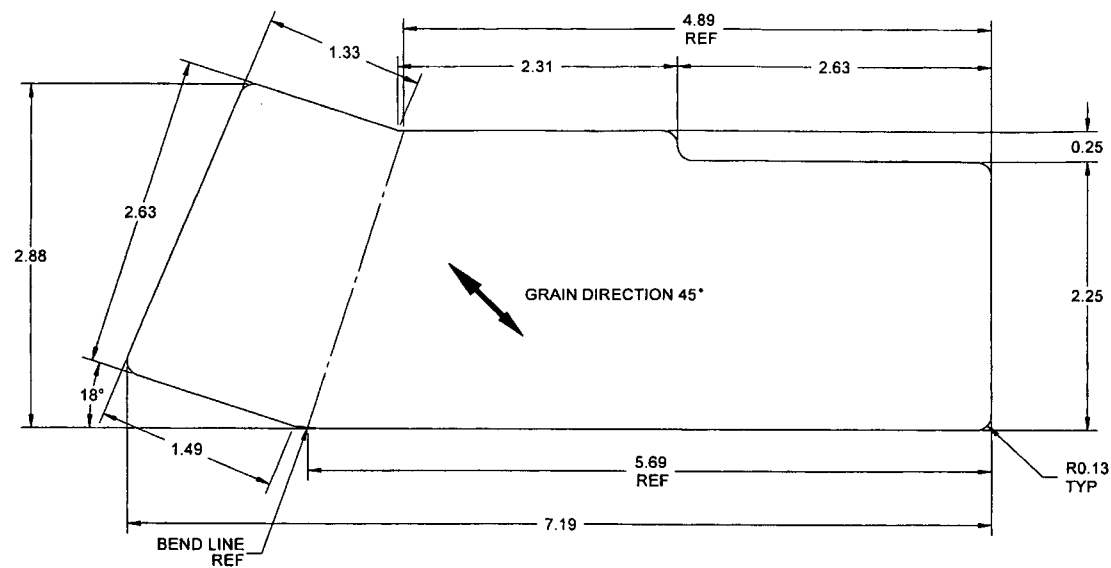
**D3983-5 HINGE CLOSEOUT**  
(MADE FROM D3983-5F)

**RELEASED**  
2009-10-13

- NOTES:**
- 1) MATERIAL: D3983-5F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-5" AND B/N USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.06 lbs

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MFG. APPR.		D3983	SHEET 3 OF 7
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**D3983-5F HINGE CLOSEOUT FLAT PATTERN**

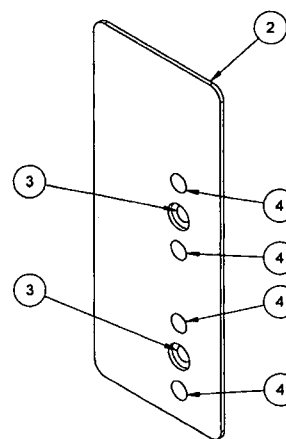
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NO. 52952

**RELEASED**  
2009-10-13

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.040
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.06 lbs

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ITEM	QTY. -047	PART NUMBER	DESCRIPTION
1	X	D3983-047	CLOSEOUT ATTACHMENT
2	1	D3983-7	PLATE
3	2	MS21059L3	ANCHOR NUT
4	4	MS20426AD3-4	RIVET



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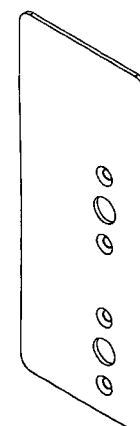
*BT 09-10-19*

**D3983-047 CLOSEOUT ATTACHMENT**

**RELEASED**  
2009-10-13  
*MD*

NOTES:  
1) MATERIAL: SEE BOM  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-047" AND B/N USING FINE POINT PERMANENT INK MARKER  
7) WEIGHT: 0.03 lbs

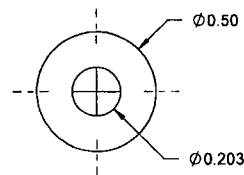
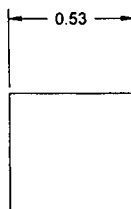
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MFG. APPR.	<i>JS</i>	D3983	SHEET 5 OF 7
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2009-10-13

**NOTES:**  
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.040  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.02 lbs

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3983</b>  TITLE <b>CLOSE OUT KIT</b>  COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED OR ON ANY PURPOSES OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	REV. /
DRAWN	<i>[Signature]</i>		SHEET 6 OF
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
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# **D3983-9 SPACER**

**RELEASED**  
2009-10-13  
*M*

## **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR,  $\phi 0.500$   
PER AMS-QQ-A-225/8 (OR AMS 4117/4122/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC M6061TR
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-9" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
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